

Ship today to Eng

Work Order ID 64481

December 6, 2010 2:36:32 PM



Page 1

Item ID: D4274-3

Revision ID:

Item Name: Plate, Aft Support

Start Date: 12/06/10 Start Qty: 2.00

Required Date: 12/06/10 Req'd Qty: 2.00

PRELIMINARY ISSUE

Accept



Setup

Start



Stop



Reference:

Approvals:

Process Plan: u

Date: _____

Tooling: _____

Date: _____

Run

Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D4274	<u>PBT</u> <u>C</u>

100



Waterjet

Memo

0.00

B10-126

FLOW CNC Waterjet

1-Cut as per Dwg
Dwg Rev: C
Prog Rev: C

2-Deburr if necessary

(2)

110



QC2- Inspect parts off machine FAI/FAIB

0.00

B10-126

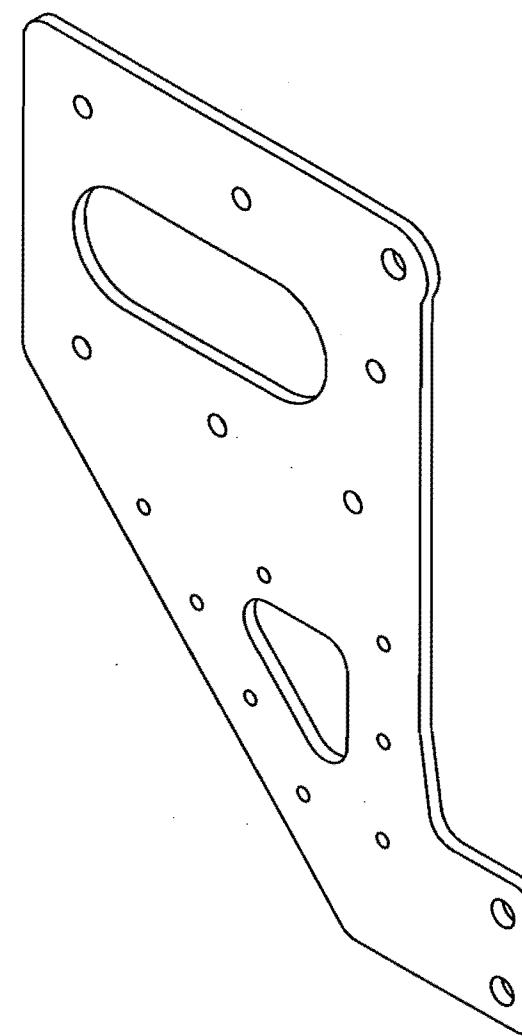
QC

Memo

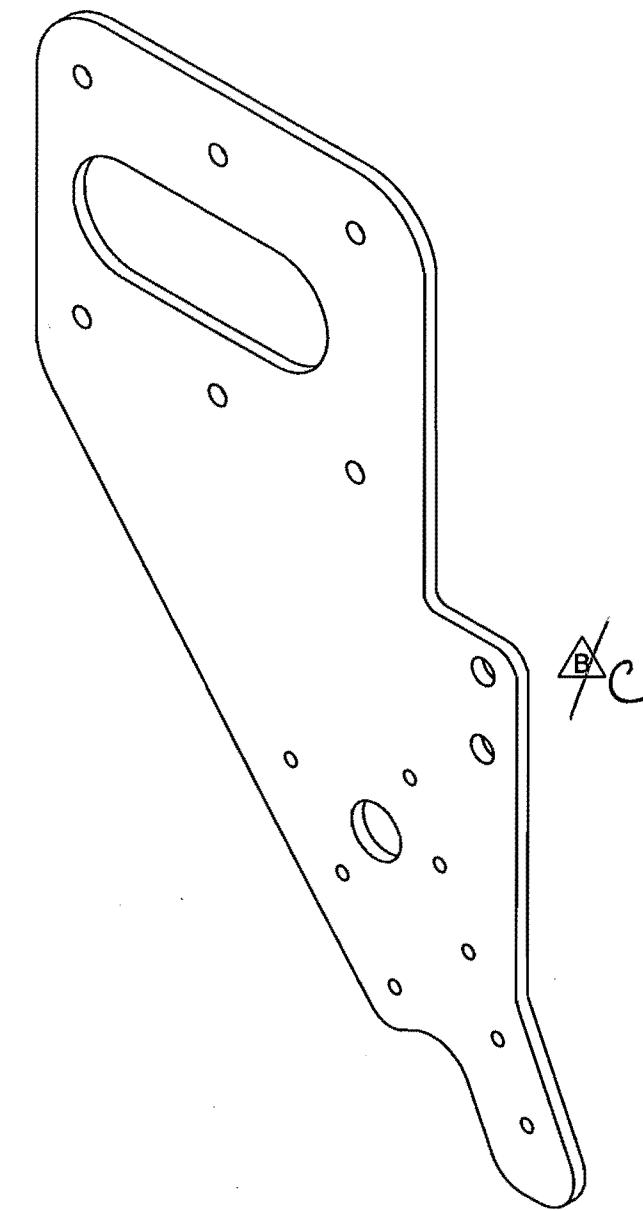
0.00

Quality Control

8 7 6 5 4 3 2 1



D4274-1 PLATE, FWD SUPPORT



D4274-3 PLATE, AFT SUPPORT

PRELIMINARY
ISSUE

0.5"

B	D4274-1, D4274-3 PLATES LENGTH INCREASED BY 0.25"; HOLES OPENED TO 0.25" FOR AN4 BOLTS		SC	10.12.02
A	NEW ISSUE		SC	10.11.30
REV.	DESCRIPTION			BY DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	DRAWING NO. D4274 REV. B SHEET 1 OF 3	SCALE NTS
DRAWN	SC			
CHECKED	W			
MFG. APPR.	M			
APPROVED	W			
DE APPR.				
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8

7

6

5

4

3

2

1

A

D

D

C

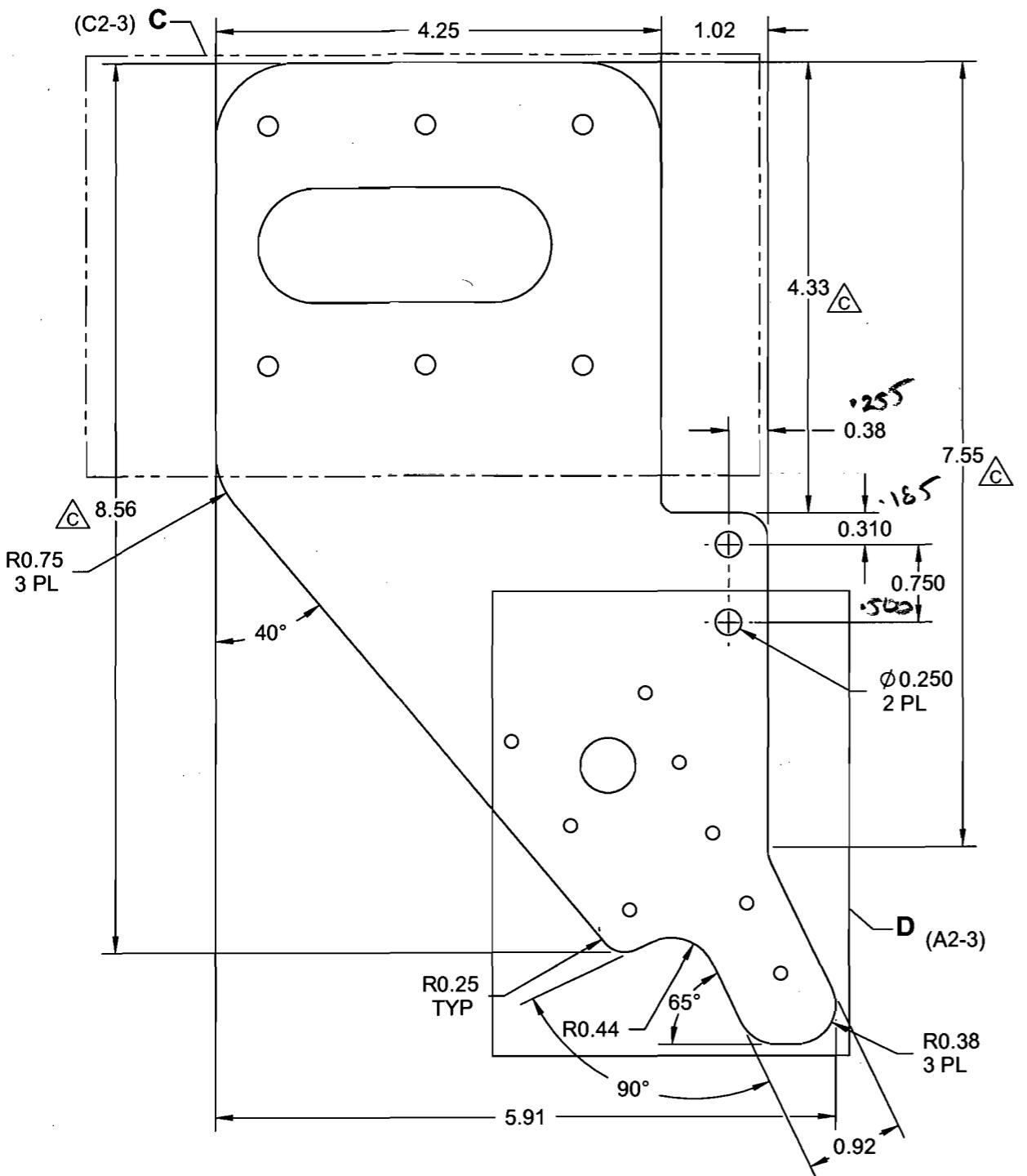
C

B

B

A

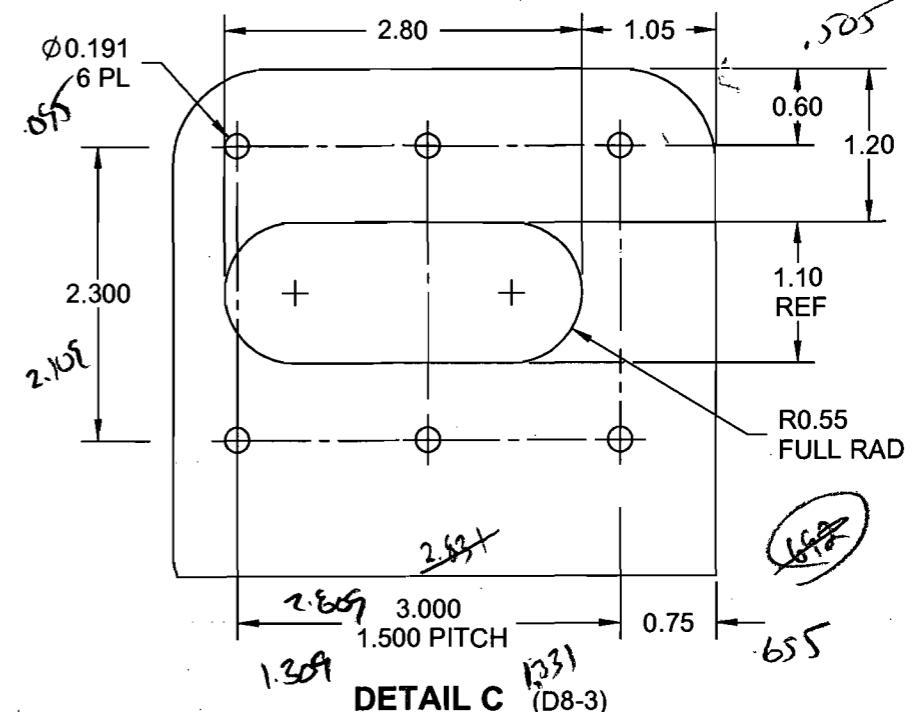
A



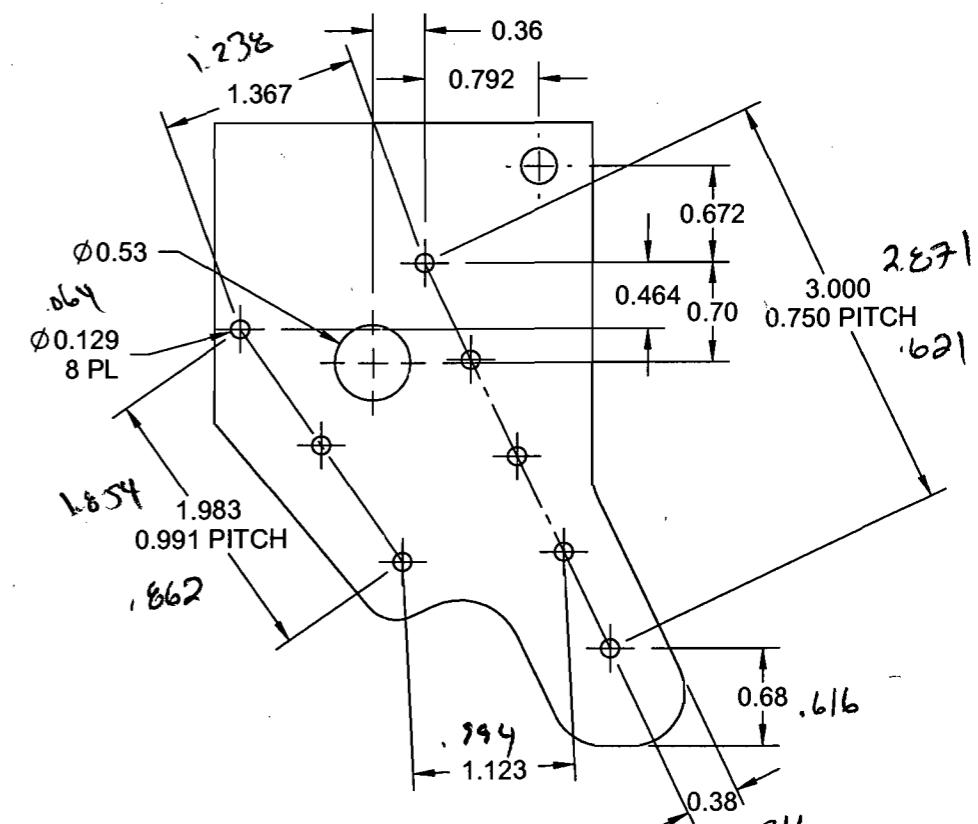
D4274-3 PLATE, AFT SUPPORT

NOTES:
1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA OR M303S11GA
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 1.05 lbs

**PRELIMINARY
ISSUE**



DETAIL C (D8-3)



DETAIL D (B5-3)

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	A1	DRAWING NO.	REV. C
MFG. APPR.	B2	D4274	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		PLATES, BASKET SUPPORT	NTS
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DART AEROSPACE LTD	Work Order:	64481
Description: PLATE, AFT SUPPORT	Part Number:	D4274-3
Inspection Dwg: D4274-3, Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .129	+ .005 - .001	.131	✗		✓ HB02	
Ø .191	+ .005 - .001	.193	✗		✓	
Ø .250	+ .005 - .001	.251	✗		✓	
Ø .53	.512 - .001	.530	✗		✓	
4.25	+ .030	4.259	✗		✓	
1.02	+ .030	1.018	✗		✓	
4.33	+ .030	4.328	✗		✓	
.38	+ .030	.378	✗		✓	
.310	+ .010	.312	✗		✓	
.750	+ .010	.750	✗		✓	
7.55	+ .030	7.586	✗		✓	
.92	+ .030	.923	✗		✓	
5.91	+ .030	5.917	✗		✓	
8.56	+ .030	8.551	✗		✓ PROB02	
2.86	+ .030	2.80	✗		✓	
1.05	+ .030	1.055	✗		✓	
.60	+ .030	.597	✗		✓	
1.20	+ .030	1.210	✗		✓	
1.10	+ .030	1.095	✗		✓	
.74	+ .030	.758	✗		✓	
3.005	+ .010	3.008	✗		✓	
1.500	+ .010	1.499	✗		✓	
2.300	+ .010	2.301	✗		✓	

Measured by:	HB	Audited by:	S	Prototype Approval:	
Date:	10-12-06	Date:	10/12/06	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD	Work Order:	64481
Description: PLATE, AFT Support	Part Number:	D4274-3
Inspection Dwg: D4274-3, Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by: 1B	Audited by: S	Prototype Approval:
Date: 10-12-6	Date: 10/10/06	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

8 7 6 5 4 3 2 1

D

D

C

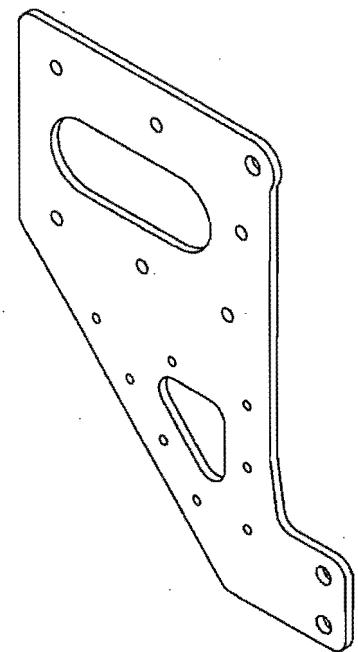
C

B

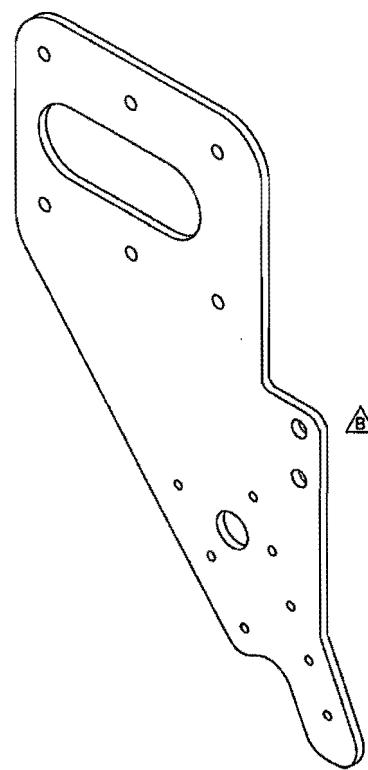
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A

A



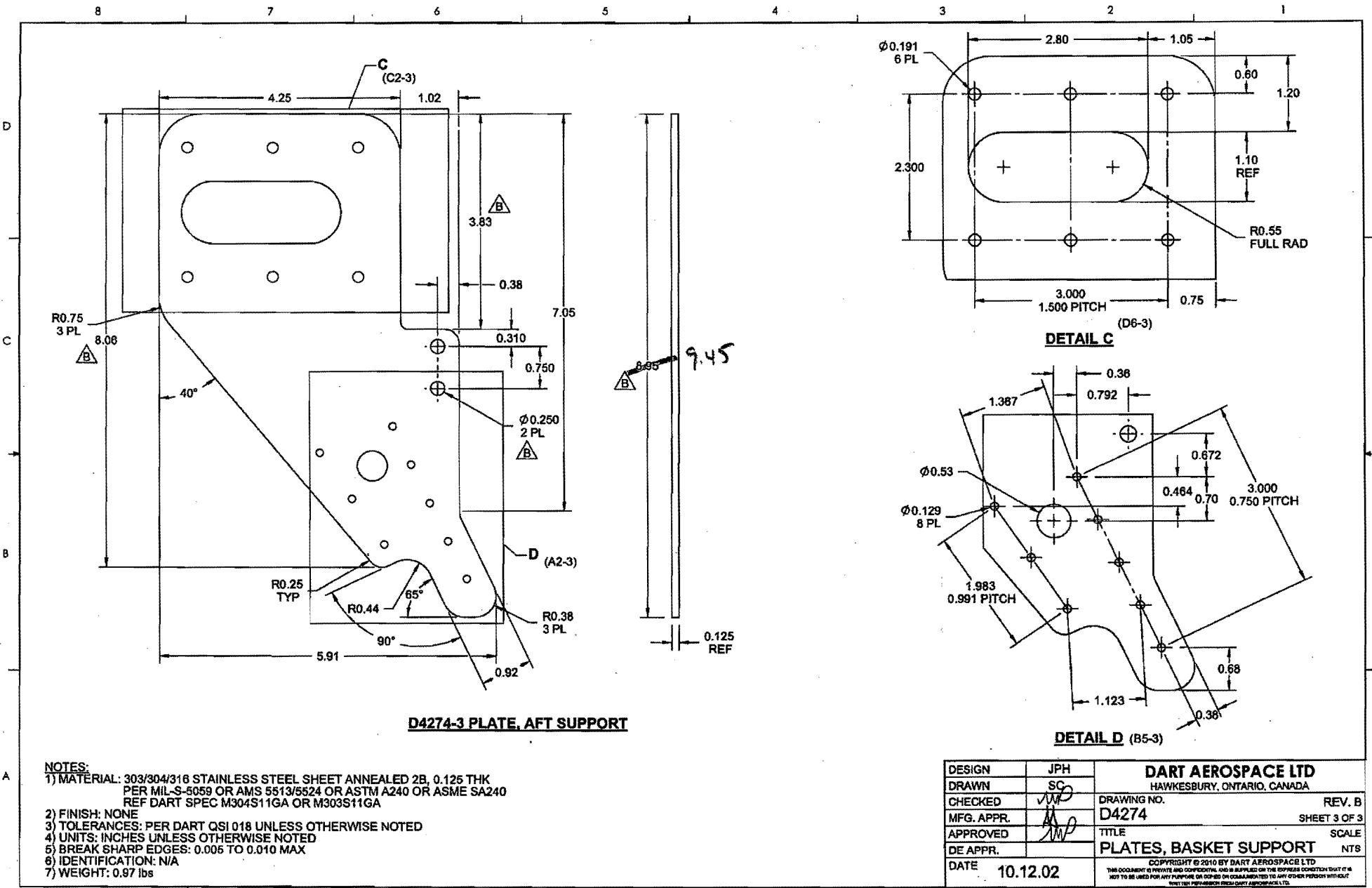
D4274-1 PLATE, FWD SUPPORT



D4274-3 PLATE, AFT SUPPORT

REFERENCE ONLY

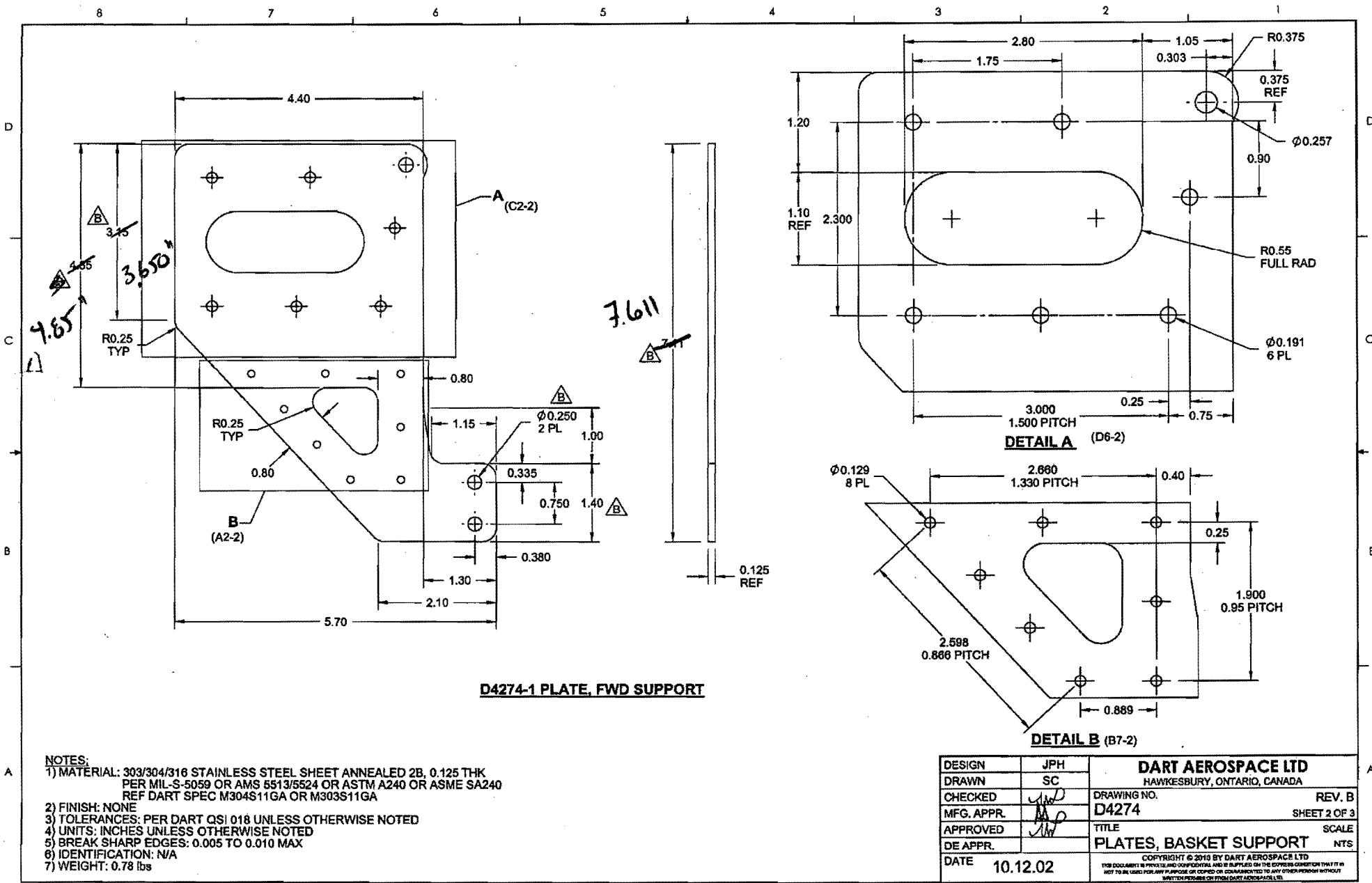
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A	NEW ISSUE			SC	10.11.30
REV.	DESCRIPTION			BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	SC				
CHECKED	W	DRAWING NO. D4274			REV. B
MFG. APPR.	W				SHEET 1 OF 3
APPROVED	W	TITLE PLATES, BASKET SUPPORT			SCALE NTS
DE APPR.					
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DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VM	DRAWING NO.	
MFG. APPR.	AM	REV. B	D4274
APPROVED	MP	SHEET 3 OF 3	
DE APPR.		TITLE	PLATES, BASKET SUPPORT
DATE	10.12.02	SCALE	NTS

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REFERENCE ONLY



L Lacelle

From: Mike Petsche [mpetsche@dartaero.com]
Sent: December 6, 2010 1:56 PM
To: Sridhar Chintapalli; 'Chris Provencal'; 'L Lacelle'; 'Eric Charbonneau'; 'David Duval'
Cc: 'David Shepherd'
Subject: RE: NEW PARTS PLEASE!!!!

Oh.....and they need to be fedex'ed to us today!

Thanks

xoxoxoxox

From: Mike Petsche [mailto:mpetsche@dartaero.com]
Sent: December 6, 2010 1:55 PM
To: Sridhar Chintapalli; 'Chris Provencal'; 'L Lacelle'; 'Eric Charbonneau'; 'David Duval'
Cc: 'David Shepherd'
Subject: NEW PARTS PLEASE!!!!
Importance: High

42
D4274-1 and D4274-3

I know it's a little late in the game.... But Sri, as I mentioned in my email this weekend, The basket is still a little too high for the 407

Could you drop everything right away and modify the D4274-1 and D4274-3 plates to make them an additional $\frac{1}{2}$ " taller than they are. Basically do exactly what you did before. But we need an additional $\frac{1}{2}$ "

Mike Petsche
DART Aerospace
Design Manager

613-632-5200
514-833-1657